

1 **THERMOFORMER FOR FORMING AND HEAT BONDING**
2 **A THERMOPLASTIC SHEET TO A SUBSTRATE**
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4

5 Cross Reference to Related Applications

6 This application is a divisional of U.S. Serial No. 09/721,298, now U.S. Patent
7 No. 6,648,043, issued on November 18, 2003.

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9 Background of the Invention

10 This invention concerns thermoforming, a widely practiced manufacturing process
11 involving the forming of preheated thin plastic sheets into molded parts. In this process, the
12 plastic sheets are preheated in an oven, and then positioned aligned with tooling in a
13 thermoforming press, the sheet drawn against tooling mold surfaces, using a pressure differential
14 or vacuum to force the heated plastic sheet into conformity with the mold surfaces. A plug assist
15 opposite the mold tooling is often used to preform the sheet into closer conformity to the mold
16 surfaces when press platens are moved together to assist in the process of thermoforming the
17 sheet against the tooling mold surfaces.

18 Often, in automated machines, sheet material is fed off a large roll, cut to a proper
19 length, then clamped about its perimeter in a clamping frame. The clamping frame and sheet is
20 advanced into an oven where the sheet is preheated to a forming temperature. The clamping
21 frame is then advanced into a press having platens mounting mold and plug assist tooling which
22 are brought together to cause the heated sheet to be formed into a part.

23 Vacuum or a differential air pressure is applied at the same time to form the sheet
24 into conformity with the molding surfaces.

25 After forming, the press is opened and the completed part is removed or

1 transferred to another station for further processing.

2 In twin sheet thermoforming, two sheets are preheated and formed as described,
3 and then fused together to form a unitary part.

4 In another version of the thermoforming process, a preheated sheet is drawn onto
5 a preformed porous substrate by a vacuum applied to the undersurface of the substrate. Such
6 process has been used for applying a cover skin layer to an automotive interior trim piece.

7 The cover layer can be adhesively bonded to the substrate. While heat activated
8 adhesives can provide a superior bond, to have a separate oven and coordinated handling of the
9 substrate as well as the sheets would add considerably to the complexity and cost of the machine.

10 In automating this process, it is usual to feed sheet material off a roll fed into a
11 loading area where a proper length is cut off, the cut sheet clamped into a clamping frame for
12 transport to an oven and thereafter to the forming press. Sometimes material rolls are wound
13 such that the edge of the web wanders laterally to some extent as the sheet is pulled off the roll.
14 This will cause some mispositioning of the cut sheets which can cause faulty parts to be
15 produced.

16 It is the object of the present invention to provide the capability of preheating a
17 substrate to bond a thermoformed sheet thereto without requiring separate additional handling of
18 the substrate.

19 It is a further object of the present invention to provide an accurately controlled
20 feeding of sheet material into a thermoforming apparatus when being unwound from a roll of
21 sheet material.

1 Summary of the Invention

2 The above objects of the present invention and others which will become apparent
3 upon a reading of the present specification and claims are achieved by providing a movably
4 mounted substrate heater for each substrate tool which heater can alternatively be positioned in
5 an advanced position extending within the forming press and cantilevered over the substrate, or
6 in a retracted position withdrawn from the press. A powered drive arrangement is operated to
7 shift the heater between the respective positions during cycling of the apparatus.

8 While the sheet to be bonded to the substrate is within the oven and being
9 preheated, the substrate heater is in its advanced position within the forming press, and energized
10 to heat the substrate adhesive.

11 When the sheet being heated in the oven reaches a proper degree of softening, the
12 substrate heater is retracted out of the way to allow the heated sheet to be advanced into the press
13 and positioned over the now heated substrate.

14 The thermoforming operation then proceeds by cycling of the press to mold and
15 bond the sheet to the substrate surface to complete the part.

16 In order to prevent mispositioning of the sheets when cut from a roll of material, a
17 roll stand is provided which is movable back and forth laterally. An edge sensor is provided
18 which generates an error signal used to control a positioning drive system coupled to the stand to
19 drive the same in either direction so as to compensate for any sensed mispositioning of the web
20 edge. An electric servo motor with position feed back sensors is preferably used as the drive
21 system.

22 The apparatus may be used to produce left and right parts by providing

1 simultaneous parallel processing of two parts in the same machine.

2 Two side-by-side clamping frames are alternatively loaded with sheets
3 successively cut from the roll and deposited on side-by-side loading tables positioned in front of
4 a common sheet preheating oven. The loading tables are preferably turn tables which can rotate
5 the cut sheets and clamping frames to reorient the grain of the sheet material to be in a desired
6 proper relation to the substrate.

7 8 Description of the Drawings

9 Figure 1 is a diagrammatic plan view of the thermoformer apparatus according to
10 the present invention.

11 Figure 2 is a side elevational view of a portion of the apparatus depicted
12 diagrammatically in Figure 1.

13 Figure 3 is a top view of the top view of the apparatus of Figures 1 and 2.

14 Figure 4 is a fragmentary front elevational view of the forming press portion of
15 the apparatus with the retracting substrate heaters.

16 Figure 5 is an end view of a sheet material roll stand included in the apparatus of
17 Figure 1.

18 Figure 6 is a front view of the roll stand shown in Figure 3.

19 Figure 7 is an enlarged front view of one of the retracting substrate heaters,
20 mounting, and positioning drive system.

21 Figure 8 is a plan view of the radiant heater and related components shown in
22 Figure 6.

Figure 9 is an end view of the radiant heater and related components shown in Figures 6 and 7.

Detailed Description

In the following detailed description, certain specific terminology will be employed for the sake of clarity and a particular embodiment described in accordance with the requirements of 35 USC 112, but it is to be understood that the same is not intended to be limiting and should not be so construed inasmuch as the invention is capable of taking many forms and variations within the scope of the appended claims.

Referring to the drawings and particularly Figure 1, the apparatus 10 according to the present invention includes a feed roll stand 12 and a feed system for feeding a strip of plastic sheet material 14 unwound from the roll over each of a pair of aligned rotary tables 16. A movable cut off sheet support 18 has a traveling cutter 19, which is operated to grip and pull a segment of plastic sheet from the roll, cut the same off, and position a cut off piece 20A, 20B on a respective table 16A or 16B.

Clamping frames 22A, 22B are shuttled to and from ovens 24 to be positioned over the tables 16A, 16B. A common holder may be used to shuttle the separate clamping frames 22A, 22B to and from the various stations.

The sheets 20A, 20B are rotated on the tables 16A, 16B to be properly oriented with respect to preformed substrate panels 26A, 26B which have been loaded onto tooling 28A, 28B in a lower platen 29 of a thermoforming press 30.

The tables 16A, 16B are thereafter elevated to position the sheets 20A, 20B within

1 a respective clamping frame 22A, 22B, which has clamps operated to secure the sheets 20A, 20B
2 within the respect frame in the well known manner. After lowering of the tables, the clamping
3 frames 22A, 22B are shuttled back into the oven 24. A common holder can be used to move
4 both frames 22A, 22B at once. Such equipment is well known in the art and is not described
5 here in any detail.

6 According to the one feature of the present invention, the roll stand 12 is mounted
7 to be movable laterally in either direction by operation of a drive motor 32 so as to maintain the
8 position of the web edge, which is monitored by a suitable sensor 34 positioned adjacent to one
9 edge. Thus, if the web shifts laterally as it is unwound from the roll, there is a compensating
10 shift laterally of the roll stand 12 in the opposite direction to bring the edge back into proper
11 position prior to cut off of a sheet 20A, 20B.

12 According to another feature of the present invention, substrate heaters 36A, 36B
13 are mounted adjacent the press 30 to be movable to an advanced position within the press 30
14 cantilevered out over substrates 26A, 26B loaded onto the tooling 28A, 28B on the lower platen
15 29, the heaters 36A, 36B thereafter retracted out of the press 30 by operation of respective
16 positioning drive systems 38A, 38B.

17 The heaters 36A, 36B, preferably of the radiant quartz type, are advanced over the
18 substrates 26A, 26B and energized after the substrates 26A, 26B are loaded onto the tooling and
19 during the time when the corresponding sheet pieces 20A, 20B are being preheated in the oven
20 24. When the sheet pieces 20A, 20B begin to be advanced into the press 30, the heaters 36A,
21 36B are deenergized and retracted out of the way.

22 Certain further details of such an apparatus can be seen in Figures 2-4. The rotary

1 cut off tables 16A (and table 16B not shown) include ball support bearings 40 to support the
2 weight of an under plate 42 and top plate 44. Strip heaters 46 may be provided on the under
3 surface of the top plate 44 to prewarm the plastic sheets.

4 Elevator drives 48 enable raising the table 16A after a cut off plastic sheet 20A is
5 deposited thereon and rotated by rotary drive 50.

6 A traveling cut off frame 52 with a gripper bar 54 and traversing cut off wheel 56
7 (Figure 3) is operated by a drive system 58 to grip and pull off a section of plastic material from a
8 material roll on the roll stand 12, and cut off a correct length to form the sheets 20A, 20B.

9 The clamping frames 20A, 20B are positioned over the table 16A, 16B when
10 shuttled out of the oven 24 by a clamping frame drive motor system 60 mounted on a holder for
11 the clamping frames 20A, 20B.

12 The tables 16A, 16B are elevated to position the sheets 20A, 20B within a
13 respective clamping frame 20A, 20B with a series of clamping cylinders actuated to hold the
14 sheets 20A, 20B about their perimeters, in the manner well known to those skilled in the art.

15 The oven 24 is of a well known type having a top heater 62 and bottom heater 64
16 supported on an elevator mechanism 66 which lowers the bottom heater 64 as the heating cycle
17 continues to compensate for sag of the sheets 20A, 20B as they are warmed.

18 The clamping frames 22A, 22B are driven into the thermoformer press 30 after
19 being heated to the proper degree, between the lower platen 29 and an upper platen 68.

20 The lower platen 29 is mounted to be pivoted out as shown to position the
21 substrate tooling 28A, 28B in a position to allow loading of the substrates 26A, 26B and
22 unloading of a completed part, one or more power cylinder 70 used to carry out the tilting.

1 The upper platen 68 is driven up and down on threaded posts 72 by an electric
2 motor drive system 74, in the well known manner.

3 Tooling (not shown) is provided on the upper platen 68 to carry out the
4 thermoforming, and may include a vacuum box for forming a concavity in the sheet to assist in
5 conforming the sheet to the substrate shape, also in the well known manner.

6 The substrates 26A, 26B rest on the bottom platen tooling 28A, 28B, which is
7 provided with vacuum passages for creating a vacuum forming of the sheets against the
8 substrates 26A, 26B, again in the well known manner.

9 The bottom platen 29 (shown raised in Figure 4) is similarly supported on
10 threaded posts 76 and driven up and down thereon by an electric motor powered drive system 78.

11 The substrate heaters 36A, 36B are each mounted on a framework 80A, 80B
12 cantilevered from a respective side of the press frame work 82, reinforced by a preheater frame
13 81A, 81B.

14 As best seen in Figures 7-9, the heater units 84A, 84B are suspended from a
15 respective holders 85A, 85B supporting opposing sets of rollers 90A, 90B which can roll along
16 bars 91 welded to the bottom of the framework 82, driven by an electric motor drive system 86A,
17 86B. The heater drive system include a sprocket driven toothed belt 88A, 88B passing around on
18 sprockets 94A, 94B to be able to be advanced into the press to be cantilevered in a position
19 projecting over a respective substrate while the sheet pieces are being heated in the oven 34. The
20 belts 88A, 88B are attached at either end to tensioners 93A, 93B.

21 The feed roll stand 12 (best seen in Figures 5 and 6), is of a design able to
22 accommodate multiple rolls of sheet material on a wheel 96 having four detachable support rods

1 98 each able to hold a roll 102 of sheet stock. End plates 100 are notched to receive a respective
2 rod end, held by latches 104. An axle shaft 106 is revolvably supported on end frames 108 and a
3 bottom frame 120 supported on roller wheels 110 resting on floor plates 112. An air motor drive
4 122 controlled by a manually actuated valve enables rotation of the wheel 98 to bring a selected
5 roll 102 into proper feed position.

6 A VFD motor 114 drives threaded shafts 116 received in drive nuts 118 attached
7 to the underside of the bottom frame 120 to enable side-to-side or lateral compensating
8 adjustment of the roll stand position in response to error signals received from the sensor 34.
9 Suitable position feed back sensors (not shown) are typically used with the positioning motor in
10 the well known manner to produce a stable, responsive feed back control system. A servo motor
11 could also be used instead of a VFD motor.